

Work Order ID 76051

\*76051\*

Page 1

November-03-11 12:46:51 PM

Item ID: D350-636-012

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Skidtube RH

Stop \*NS2\*

Start Date: 03/11/2011 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 17/11/2011 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 11/11/03

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2750	F
D3492	C

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

ml 11 11 28 11  
mls 11-11-28

B76051RH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Work Order ID 76051

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Item ID: D350-636-012

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 03/11/2011 Start Qty: 1.00

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Required Date: 17/11/2011 Req'd Qty: 1.00

**\*1\***

Customer:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
<b>*110*</b>									
Skidtubes	<b>Memo</b>	0.00							
Skidtubes	1- Pick D2600-3 Bent ✓								
	2- Debur FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750 ✓								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr. ✓								
	4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting ✓								
	5- Drill only two fwd step holes using DT9616. Ensure proper positioning. ✓								
	6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K) ✓								
	7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE*** ✓								
	8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side) ✓								
	9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". ✓								
	10-Open up holes of Detail A to 0.297" (total of 2 holes per side) ✓								

*DL*  
*11/11/16*

W/O:		WORK ORDER CHANGES					
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Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left

from bending as per QSI 004

A/R Aluminum Rod batch: M118 735

8E11-11-16

12-Grind welds flush as per Dwg D2750

DP 11-11-16

120

QC10- Inspect visual per QSI004- ground welds

0.00

**\*120\***

QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

QC

Memo

0.00

Quality Control

S u l u l 17

S u l u l 17

(u)

W/O:		WORK ORDER CHANGES					
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Revision ID:

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Item Name: Skidtube RH

Start Date: 03/11/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 17/11/2011 Req'd Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*140*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

*JW* 11-11-17

*BE* 11-11-17

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 03/11/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 17/11/2011 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 <b>*160*</b> Skidtubes Skidtubes	Skidtubes  Memo 1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.  2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.  3-Open float holes to .500" (4 per Side)  4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)  5-Deburr and blow out all chips from inside of tube  6-Prepare tube for welding, remove alodine as required.  7-Bond web D2739 in place as per QSI 015 A/R Sikaflex-291 batch: 119399 exp. date: 12/08/13  8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: M118735 BE 11-11-10  9- At section AP-AP drill out x-bolt spacer to 0.404" BE 11-11-10  10-Grind welds flush as per Dwg D2750  11-Spot face ground handling holes section (total of 4 places per side) as per	0.00  0.00							

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop **\*NS2\***

Start Date: 03/11/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 17/11/2011 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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dwg D2750

12-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

0.00

**\*170\***

S u l u l z z

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

**\*180\***

S u l u l z z

QC

Memo

0.00

Quality Control

B 11/11/21

ⓐ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop **\*NS2\***

Start Date: 03/11/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 17/11/2011 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190 Pressure Wash per QSI005 4.3

0.00

**\*190\***

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

*IX M-L 11/11/22*

200 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

**\*200\***

Powdercoat

Powder Coating

Memo

0.00

START TIME: 7:50

OVEN TEMPERATURE: 320

FINISH TIME: 8:20

*IX M-L 11/11/23*

210 QC3- Inspect Part Finish 0.00

**\*210\***

QC

Quality Control

Memo

0.00

Inspect for foreign object per QSI 024

*1 BL 11-11-23.*

*118439*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 03/11/2011 Start Qty: 1.00

**\*1\***

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Required Date: 17/11/2011 Req'd Qty: 1.00

**\*1\***

Customer:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
<b>*230*</b>									
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per dwg D2750								
	2-Inspect for Foreign Objects								
	3-Spray inside of tube with "LPS-3"								
	batch: <u>WIA</u>								
	4-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750								
	SIKA FLEX 241								
	BATCH: <u>M119243</u>								
	EXP DATE: <u>12/01</u>								
	5-assemble o'ring to plug as per dwg D3492 and apply o'ring lube								
	A/R 55-o'ring lube batch: <u>M110349</u>								
	6-Coat all exposed fasteners with "LPS Procyon"								
	batch: <u>M114596</u>								

124 / M114596

W/O:		WORK ORDER CHANGES					
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Revision ID:

Item Name: Skidtube RH

Stop **\*NS2\***

Start Date: 03/11/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 17/11/2011 Req'd Qty: 1.00

**\*1\***

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Run Start **\*NR1\***

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Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
<b>*240*</b>									
QC	Memo	0.00							
Quality Control									
250	Pick Kit	0.00							
<b>*250*</b>									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
<b>*260*</b>									
QC	Memo	0.00							
Quality Control									

*Sub 1/75*

*11/11/25*

*11 . 11 . 28 (1)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
<b>*270*</b>	Packaging								
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-012								
280		0.00							
<b>*280*</b>	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

MF 11-11-28

W/O:		WORK ORDER CHANGES					
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# Picklist Print

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Work Order ID: 76051

**\*76051\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 03/11/2011

Required Date: 17/11/2011

Start Qty: 1.00

Required Qty: 1.00

**Comments:** IPP Rev:102.09.25Rearranged procedure stepsKJ  
 IPP Rev:J 06-03-29 As per Rev D EC  
 IPP Rev:K 06-07.13 As per dsi9343 EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC  
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC  
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O  
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as  
 per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4-1032-225		Purchased	No				Each	2,422.000		38			

**\*AI S4-1032-225\***

Insert

\*\*

11/11/2011

Location	Loc Qty	Loc Code
ST281	2422	
108696	502	
110768	62	
118386	858	
118966✓	1000	

38.

AN3C5A

Purchased

No

230

Each

1,131.000

34

34

**\*AN3C5A\***

Bolt

\*\*

11/11/2011

Location	Loc Qty	Loc Code
FP-A	7	
115835	7	
ST350	1124	
116419	28	
117343	17	
117764	166	
117872	2	
118451✓	411	
119127	500	

34.

W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

November-03-11 12:46:56 PM

Work Order ID: 76051

\*76051\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 03/11/2011

Required Date: 17/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

276.0000

4

4

\*AN3C6A\*

BOLT

\*\*

11/11/24

## Location

## Loc Qty

## Loc Code

FP-A

1

111982

1

ST350

100

119449

100

ST351

175

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422 ✓

120

AN6C44A

Purchased

No

230

Each

81.0000

4

4

\*AN6C44A\*

BOLT

\*\*

11/11/24

## Location

## Loc Qty

## Loc Code

FG

2

103964

2

ST343

79

118387

9

118985

40

119125

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 3

November-03-11 12:46:56 PM

Work Order ID: 76051

\*76051\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 03/11/2011

Required Date: 17/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

105.0000

1

1

\*AN8C35A\*

BOLT

\*\*

11/11/24

Location

Loc Qty

Loc Code

FP

69

117511

3

118286

66

FP-A

1

115960

1

ST345

34

117834

34

ST346

1

114442

0

115188

0

115960

1

AN960C10L

\* NAS1149C0332 /  
R

Purchased

No

230

Each

0.0000

38

38

\*AN960C10I \*

washer

D2745

Manufactured

No

230

Each

181.0000

8

8

\*D2745\*

Bushing

\*\*

58. 11-11-23.

\*\*

11/11/24

Location

Loc Qty

Loc Code

FP-A

81

69529

1

74446

80

ST021

100

71835

100

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

November-03-11 12:46:56 PM

Work Order ID: 76051

\*76051\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 03/11/2011

Required Date: 17/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3488-042

Manufactured No

230

Each

14.0000

1

1

\*\*

\*D3488-042\*

Blade Fitting Assembly, RH

Location

Loc Qty

Loc Code

FP008

62003

69904

71883

14

1

3

10

D3492-1

Manufactured No

230

Each

86.0000

8

8

\*\*

\*D3492-1\*

Plug

Location

Loc Qty

Loc Code

FP

69531

74444 ✓

86

8

78

D3492-3

Manufactured No

230

Each

129.0000

8

8

\*\*

\*D3492-3\*

Plug

Location

Loc Qty

Loc Code

FP

74447 ✓

ST

74871

69

69

60

60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

November-03-11 12:46:56 PM

Work Order ID: 76051

**\*76051\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 03/11/2011

Required Date: 17/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

36.0000

1

1

**\*D3535-25\***

Wearshoe

\*\*

*HL 11/11/24*

Location

Loc Qty

Loc Code

FP001

26

74525 ✓

14

75040

12

FP018

10

62233

1

74592 ✓

9

D3536-25

Manufactured No

230

Each

40.0000

1

1

**\*D3536-25\***

Gasket

\*\*

*HL 11/11/24*

Location

Loc Qty

Loc Code

FP012

40

74526

2

74595 ✓

12

75039

26

D3537-1

Manufactured No

230

Each

108.0000

3

3

**\*D3537-1\***

Wearpad

\*\*

*HL 11/11/24*

Location

Loc Qty

Loc Code

FP002

101

74436 ✓

70

74597

31

FP017

7

69817

5

70686

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

November-03-11 12:46:56 PM

Work Order ID: 76051

\*76051\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 03/11/2011

Required Date: 17/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3631-1 Manufactured No

230 Each 543.0000 8 8

\*D3631-1\*

Washer

\*\*

11/11/24

Location

Loc Qty

Loc Code

ST072

543

680620 ✓

43

75548 ✓

500

5

D3791-1 Manufactured No

230 Each 21.0000 1 1

\*D3791-1\*

Wearplate

\*\*

11/11/24

Location

Loc Qty

Loc Code

FP017

21

62239

2

74527 ✓

7

74598

12

1

D3793-1 Manufactured No

230 Each 14.0000 1 1

\*D3793-1\*

Wearshoe

\*\*

11/11/24

Location

Loc Qty

Loc Code

FP001

1

73422

1

FP018

13

74591 ✓

13

1

D3793-3 Manufactured No

230 Each 18.0000 1 1

\*D3793-3\*

Wearshoe

\*\*

11/11/24

Location

Loc Qty

Loc Code

FP001

18

74593

6

75043

12

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

November-03-11 12:46:56 PM

Work Order ID: 76051

\*76051\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 03/11/2011

Required Date: 17/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230

Each

47.0000

1

1

\*D3794-1\*

Gasket

\*\*

*Handwritten signature and date 11/11/2011*

Location

Loc Qty

Loc Code

FP014

47

74529 ✓

7

74594

12

75042

28

D3794-3

Manufactured No

230

Each

29.0000

1

1

\*D3794-3\*

Gasket

\*\*

*Handwritten signature and date 11/11/2011*

Location

Loc Qty

Loc Code

FP002

29

73423

1

74530 ✓

14

74596

14

MS21043-6

Purchased No

230

Each

473.0000

4

4

\*MS21043-6\*

NUT

\*\*

*Handwritten signature and date 11/11/2011*

Location

Loc Qty

Loc Code

FG

20

103693

20

ST300

453

112314 ✓

243

117887

10

118384

200

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

November-03-11 12:46:56 PM

Work Order ID: 76051

\*76051\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 03/11/2011

Required Date: 17/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

89.0000

1

1

\*MS21083C8\*

NUT

\*\*

*M 11/11/21*

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

1

118077

1

ST303

87

115884

0

118614 ✓

43

119309

19

119436

25

NAS1149C0832R

Purchased

No

230

Each

337.0000

1

1

\*NAS1149C0832R\*

WASHER

\*\*

*M 11/11/21*

Location

Loc Qty

Loc Code

FP-B

9

114915 ✓

9

ST297

328

114915

328

NAS1515H3L

Purchased

No

230

Each

179.0000

4

4

\*NAS1515H3L \*

WASHER

\*\*

*M 11/11/21*

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

139

113362 ✓

35

118686

4

119438

100

*Hv*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

November-03-11 12:46:57 PM

Work Order ID: 76051

\*76051\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 03/11/2011

Required Date: 17/11/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

233.0000

8

8

\*\*

11/11/24

\*NAS1611-010\*

O-RING

Location

Loc Qty

Loc Code

FP

212

117460

8

118077

1

118612

3

119438 ✓

200

FP-A

21

110915

14

119307

7

NAS1611-013

Purchased

No

230

Each

194.0000

8

8

\*\*

11/11/24

\*NAS1611-013\*

O-RING

Location

Loc Qty

Loc Code

FP

105

117291

2

117887

53

119438 ✓

50

FP-A

89

116582

5

119307

84

Purchased

No

250

Each

49.0000

2

2

\*\*

11/11/25

\*AN8C21A\*

BOLT

Location

Loc Qty

Loc Code

ST343

49

118045

11

118758

38

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

November-03-11 12:46:57 PM

Work Order ID: 76051

\*76051\*

Parent Item: D350-636-012

\*D350-636-012\*


Parent Item Name: Skidtube RH

Start Date: 03/11/2011

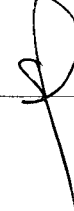
Required Date: 17/11/2011

Start Qty: 1.00


Required Qty: 1.00

 D2741  
\*D2741\*  
Blade, 350 Skidtube


Manufactured No 250 Each 10.0000

\*\* 1 1  
\$71850 


Location	Loc Qty	Loc Code
ST466	10	
70667	10	

 D3493-1  
\*D3493-1\*  
Washer

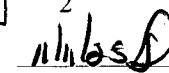
Manufactured No 250 Each 39.0000

\*\* 2 2  


Location	Loc Qty	Loc Code
ST062	39	
70697	4	
<u>71846</u>	35	

 D3532-1  
\*D3532-1\*  
Spacer

Manufactured No 250 Each 54.0000

\*\* 2 2  


Location	Loc Qty	Loc Code
ST065	54	
73342	14	
<u>74880</u>	40	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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November-03-11 12:46:57 PM

Work Order ID: 76051

\*76051\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 03/11/2011

Required Date: 17/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

89.0000

2

2

\*MS21083C8\*

NUT

\*\*

## Location

## Loc Qty

## Loc Code

FP-B

1

115884

1

ST293

1

118077

1

ST303

87

115884

0

118614

43

119309

19

119436

25

NAS1149D0863J

Purchased

No

250

Each

214.0000

2

2

\*NAS1149D0863J\*

WASHER

\*\*

## Location

## Loc Qty

## Loc Code

ST298

214

118078

114

119307

100

D2600-3-BENT

Manufactured

No

110

Each

32.0000

1

1

\*D2600-3-BENT\*

Extrusion Bent

\*\*

## Location

## Loc Qty

## Loc Code

LG

32

66875

8

73253

1

75021

9

75022

10

75023

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 12

November-03-11 12:46:57 PM

Work Order ID: 76051

\*76051\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 03/11/2011

Required Date: 17/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2744 Manufactured No 110 Each 57.0000 1 1

\*D2744\*

Cap

\*\*

BE 11-11-16

Location	Loc Qty	Loc Code
LG002	13	
62715	1	
70881	12	
WA	44	
71861	44	

D2739 Manufactured No 160 Each 6.0000 1 1

\*D2739\*

350 I Beam

\*\*

Location	Loc Qty	Loc Code
LG	6	
72155	1	
72157	2	
75037	3	

D2743 Manufactured No 160 Each 151.0000 8 8

\*D2743\*

Crossbolt Spacer

\*\*

Location	Loc Qty	Loc Code
LG	93	
71839	29	
73403	64	
LG001	58	
67766	4	
68251	54	

①

PC  
11/11/17

BE 11/11/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 13

November-03-11 12:46:57 PM

Work Order ID: 76051

\*76051\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 03/11/2011

Required Date: 17/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3490-3

Manufactured No

160

Each

58.0000

4

4

\*D3490-3\*

Cross Bolt Spacer

\*\*

BE 11-11-18

Location

Loc Qty

Loc Code

LG

18

73295

18

LG001

40

74877

40

4

D3490-1

Manufactured No

160

Each

82.0000

4

4

\*D3490-1\*

Cross Bolt Spacer

\*\*

BE 11-11-18

Location

Loc Qty

Loc Code

LG

16

67773

5

71841

11

LG001

66

62450

2

74875

64

~~1~~

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

**GENERAL NOTES:**

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WITHOUT NOTICE  
WORK ORDER  
NO. 76051 M.C.J  
11/11/03

RELEASED  
6/27/22

F	INCORPORATE OSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3635-13/35 (ZN C8-1); D3794-1/3 REPLACES D3636-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL), WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RAH		
CHECKED	MP	DRAWING NO.	REV. F
MFG. APPR.	MP	D2750	SHEET 1 OF 11
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DE APPR.	MP	350 SKIDTUBE ASSEMBLY	NTS
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

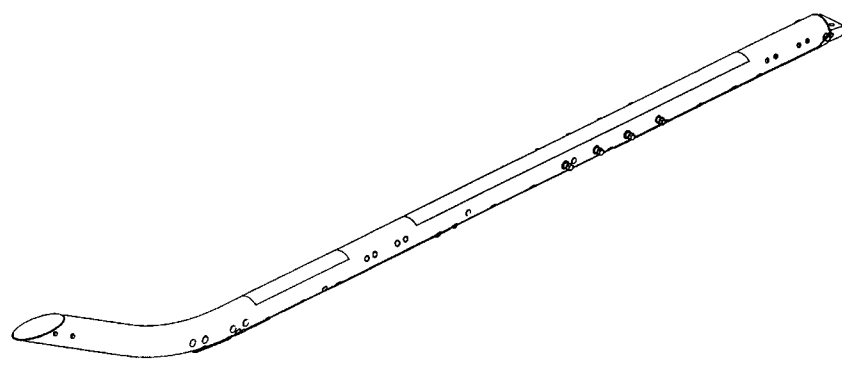
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

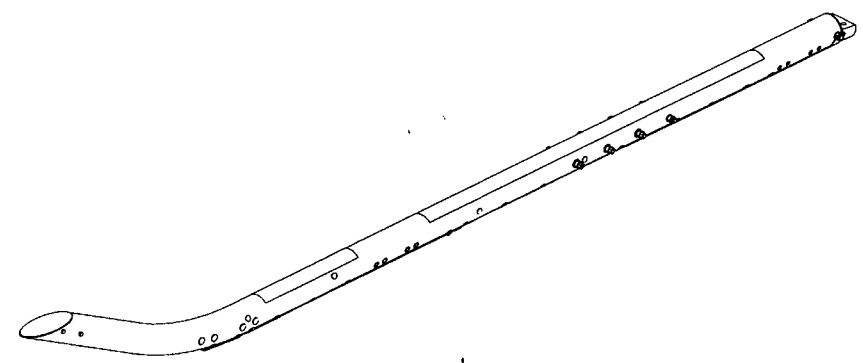
**NOTE:** Date & initial all entries



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D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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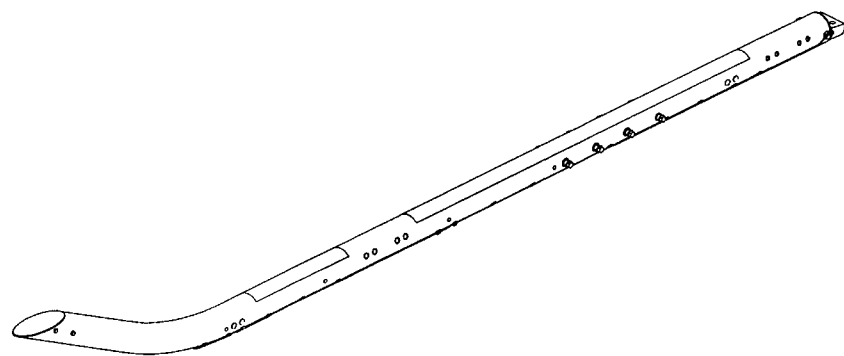
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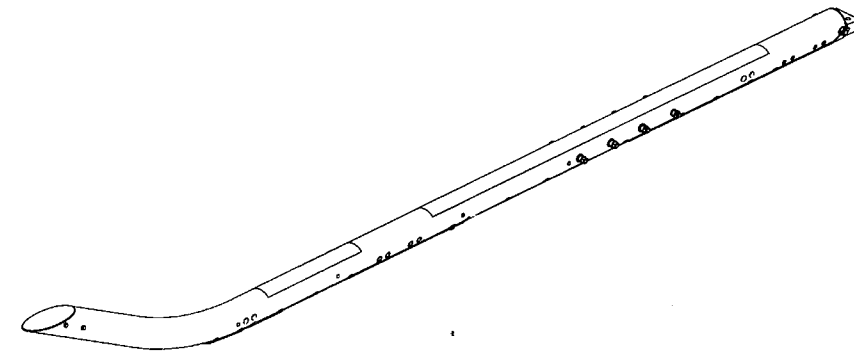
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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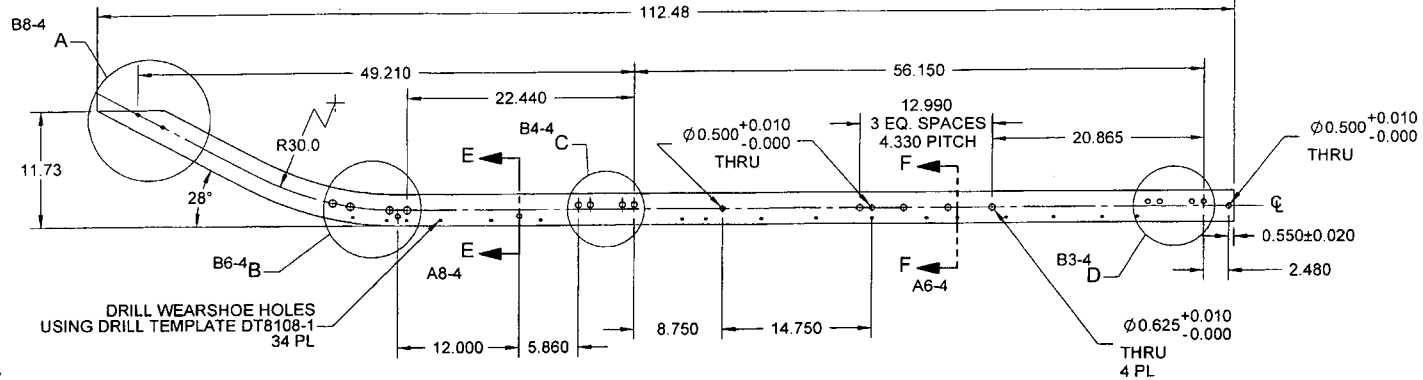
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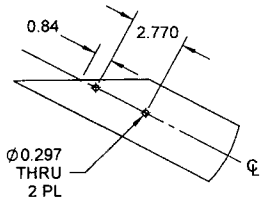
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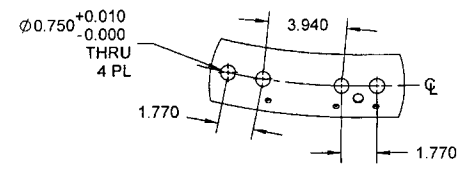


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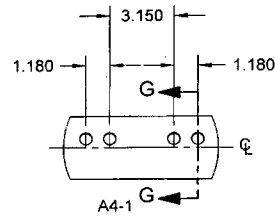
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SCALE 2X

D7-4



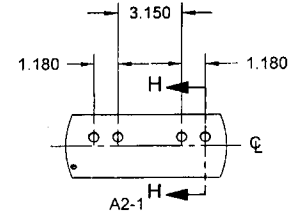
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D7-4



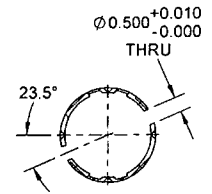
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D5-4



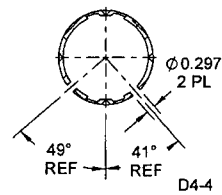
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D3-4



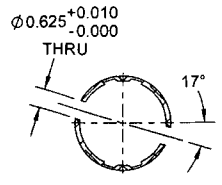
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SCALE 3X, 2 PL

D6-4



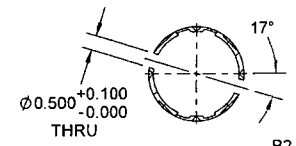
**SECTION F-F**  
SCALE 3X, 17 PL

D4-4



**SECTION G-G**  
SCALE 3X, 4 PL

B4-4



**SECTION H-H**  
SCALE 3X, 4 PL

B2-4

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APPROVED		SHEET 4 OF 11
DE APPR.		TITLE <b>350 SKIDTUBE ASSEMBLY</b>
DATE	<b>08.07.16</b>	SCALE <b>NTS</b>

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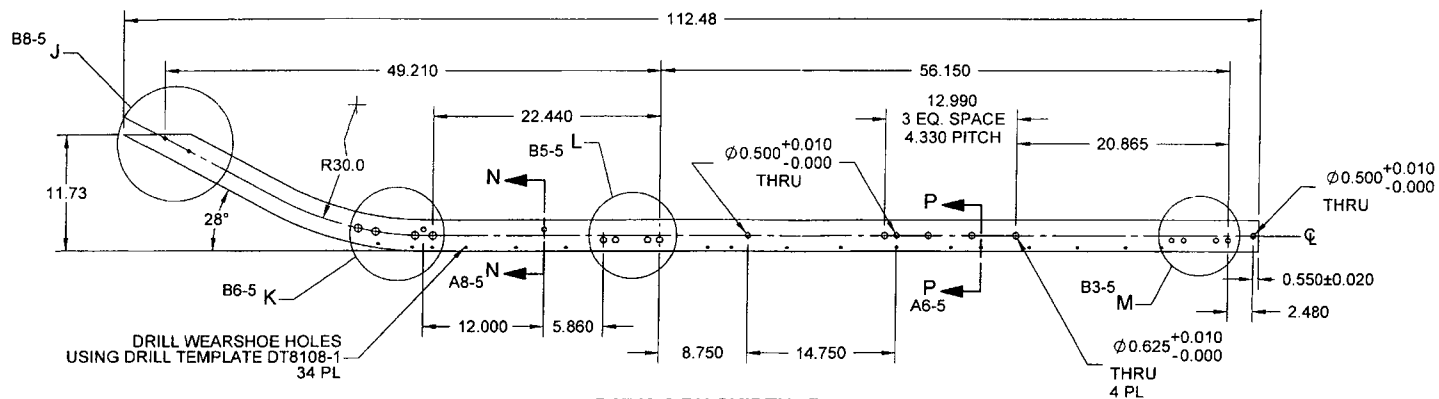
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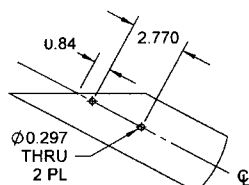
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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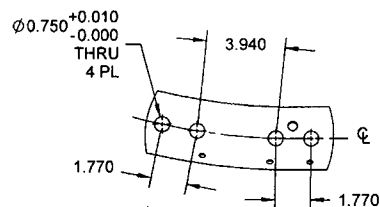
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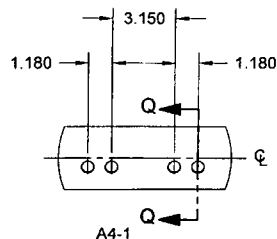
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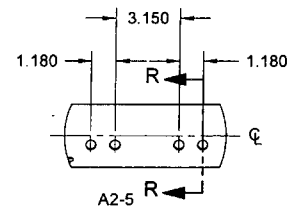
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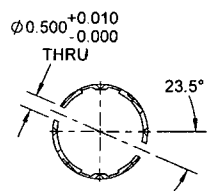
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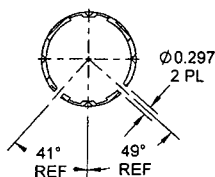
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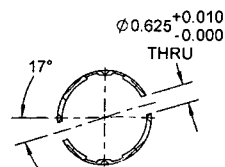
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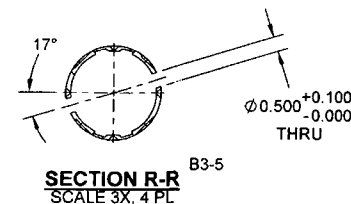
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

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MFG. APPR.			SHEET 5 OF 11
APPROVED		TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE
DE APPR.			NTS
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

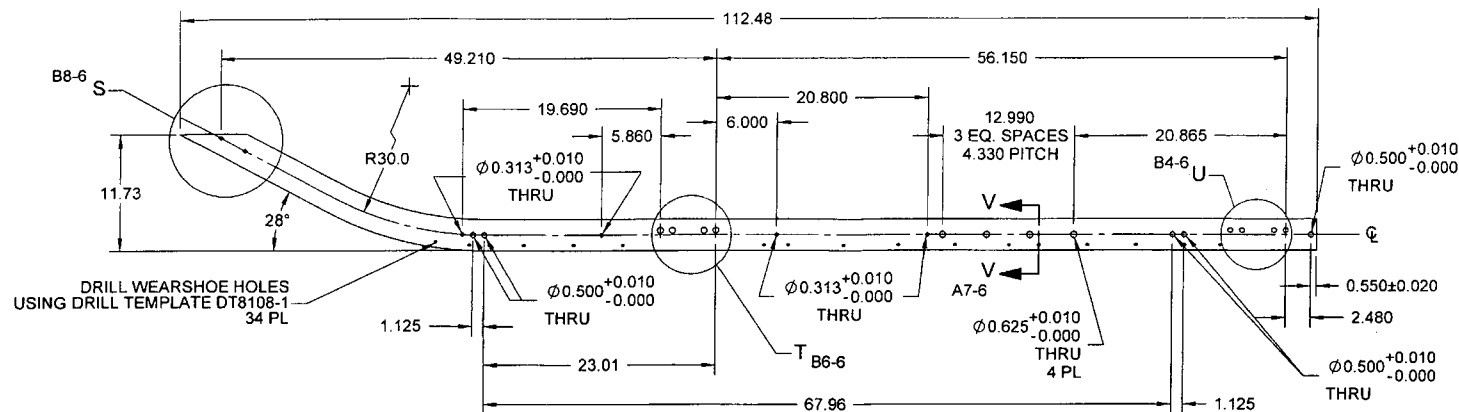
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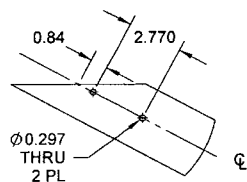
**NOTE:** Date & initial all entries



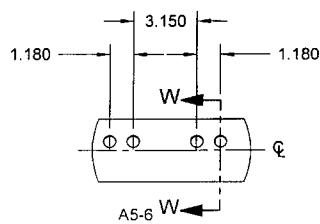
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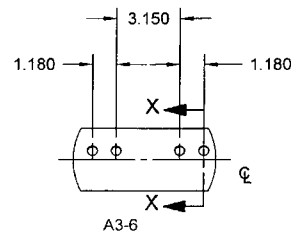
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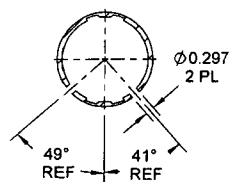
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D8-6  
SCALE 2X



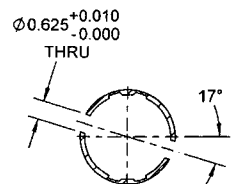
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C5-6  
SCALE 2X



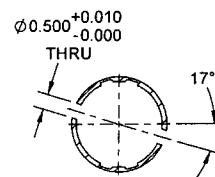
**DETAIL U**  
D3-6  
SCALE 2X



**SECTION V-V**  
C4-6  
SCALE 3X, 17 PL



**SECTION W-W**  
B6-6  
SCALE 3X, 4 PL



**SECTION X-X**  
B4-6  
SCALE 3X, 4 PL

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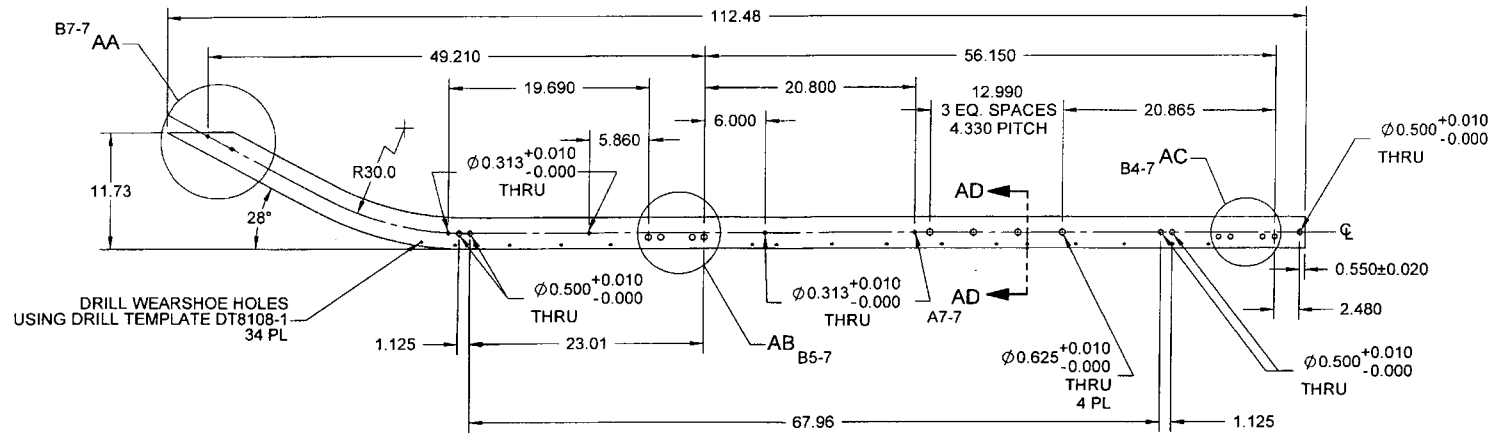
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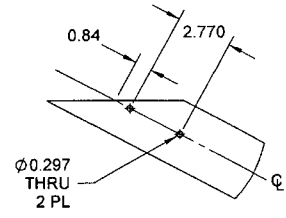
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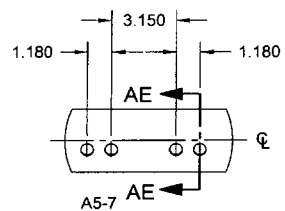
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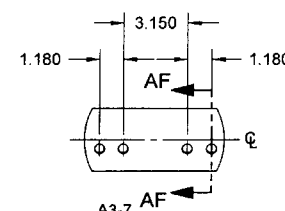
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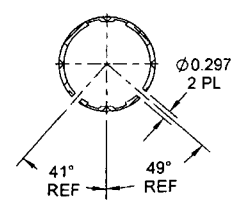
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SCALE 2X



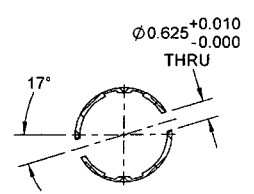
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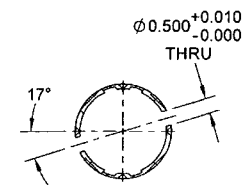
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

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MFG. APPR.		D2750	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

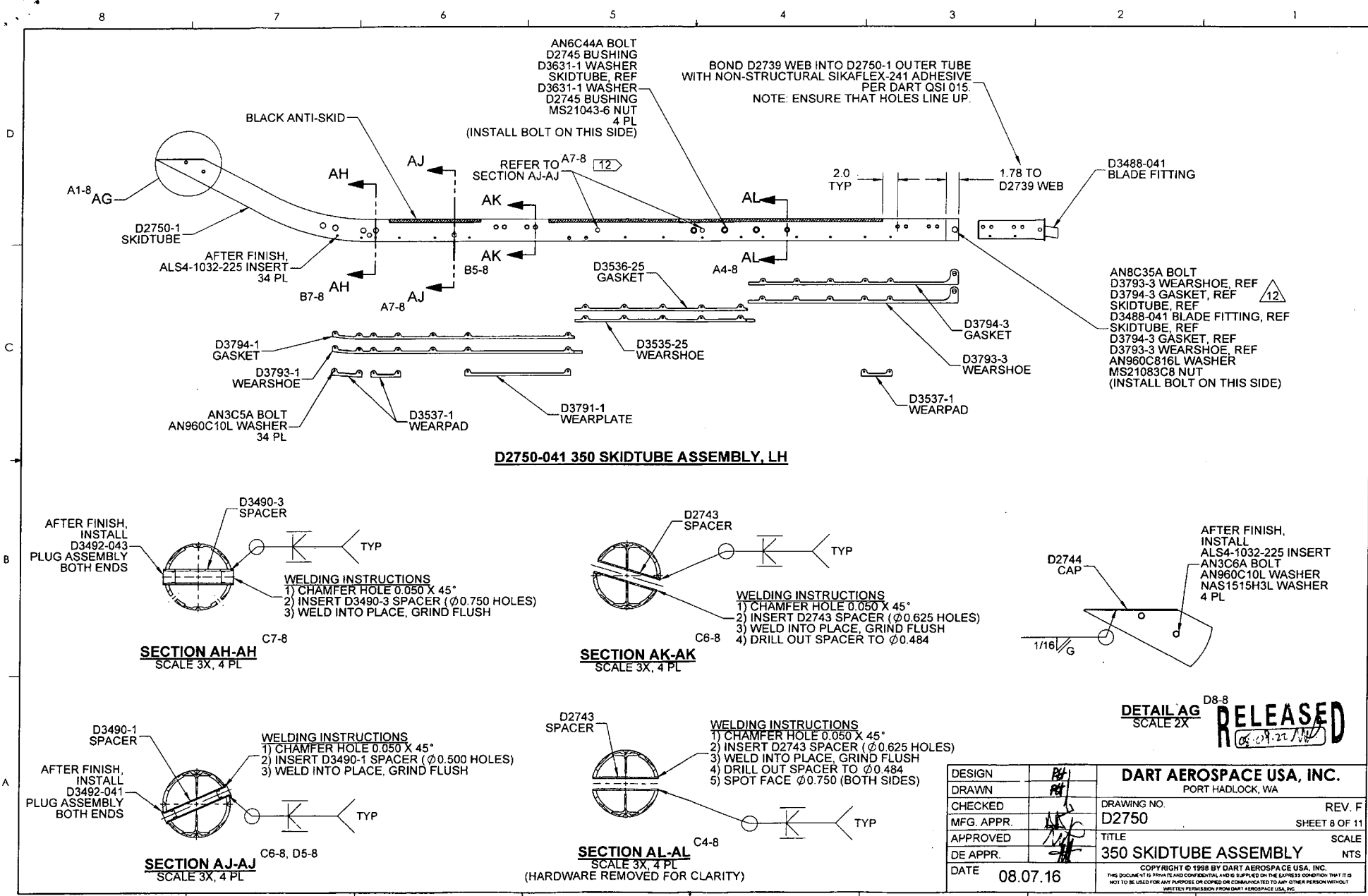
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

76051



DESIGN	PA	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 8 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

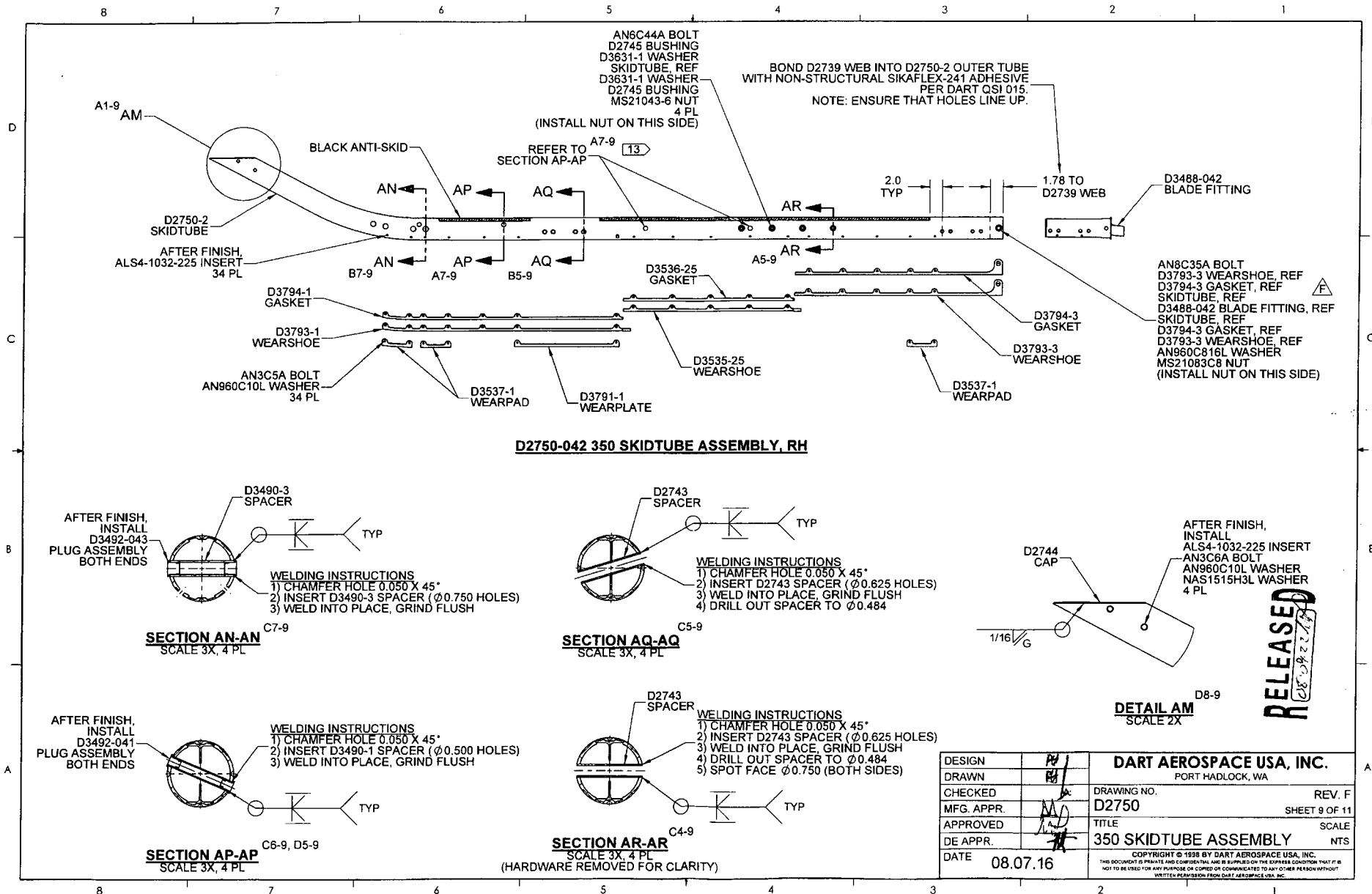
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

76051



DESIGN	76051	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	76051	PORT HADLOCK, WA	
CHECKED	76051	DRAWING NO.	REV. F
MFG. APPR.	76051	D2750	SHEET 9 OF 11
APPROVED	76051	TITLE	SCALE
DE APPR.	76051	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

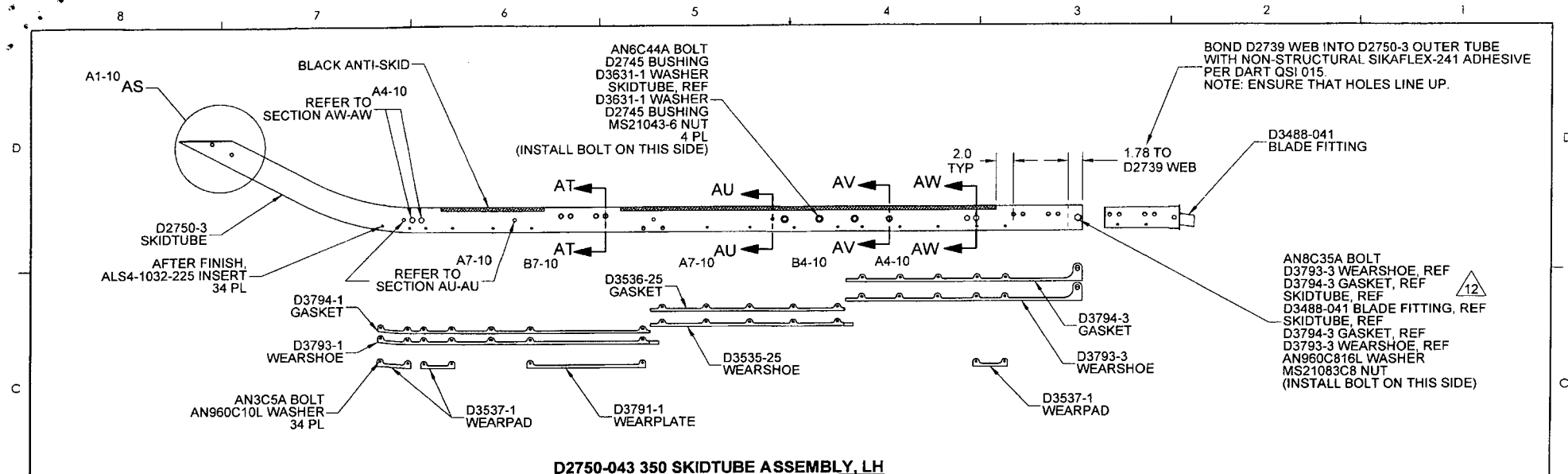
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

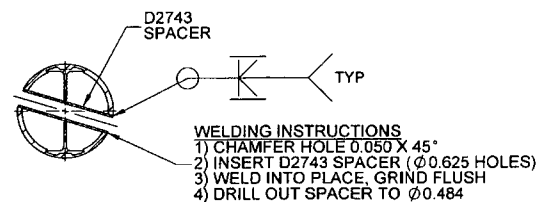
**NOTE:** Date & initial all entries



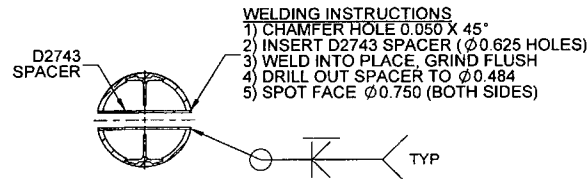
76057



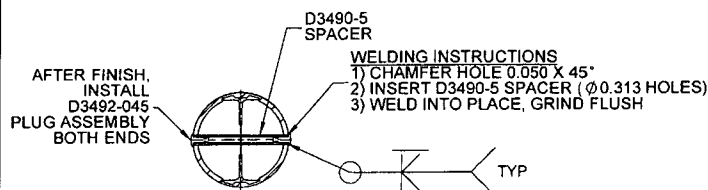
**D2750-043 350 SKIDTUBE ASSEMBLY, LH**



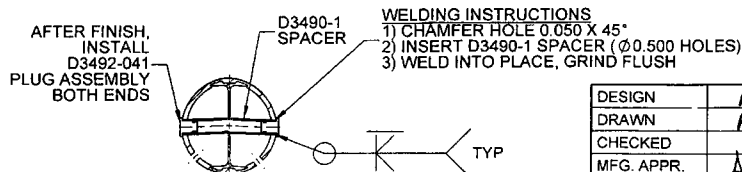
**SECTION AT-AT**  
SCALE 3X, 4 PL



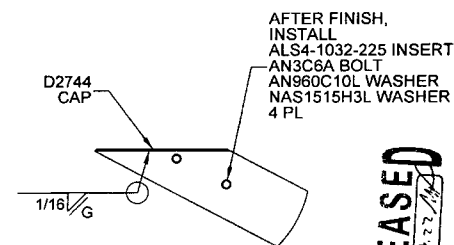
**SECTION AV-AV**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**SECTION AU-AU**  
SCALE 3X, 4 PL



**SECTION AW-AW**  
SCALE 3X, 4 PL



**DETAIL AS**  
SCALE 2X

DESIGN	AP	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PEL	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D2750</b>	SHEET 10 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	<b>08.07.16</b>	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED  
2018-08-22/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

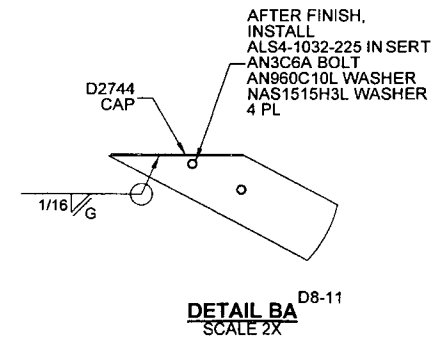
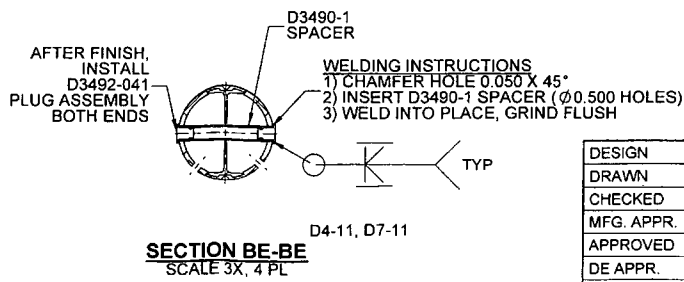
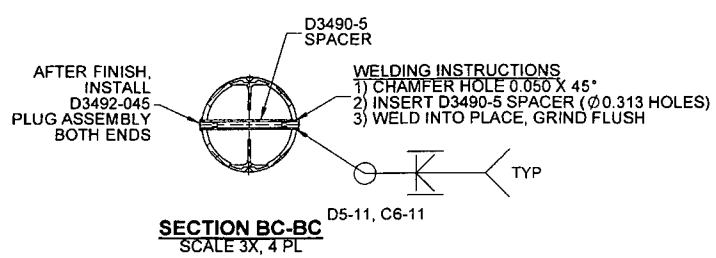
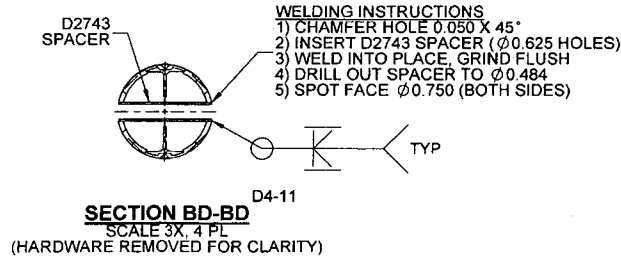
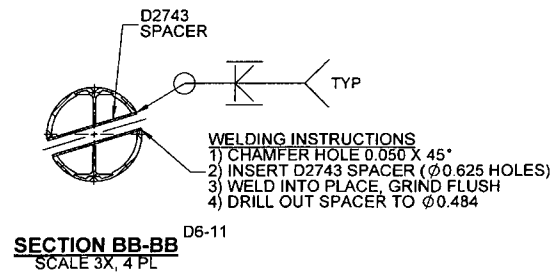
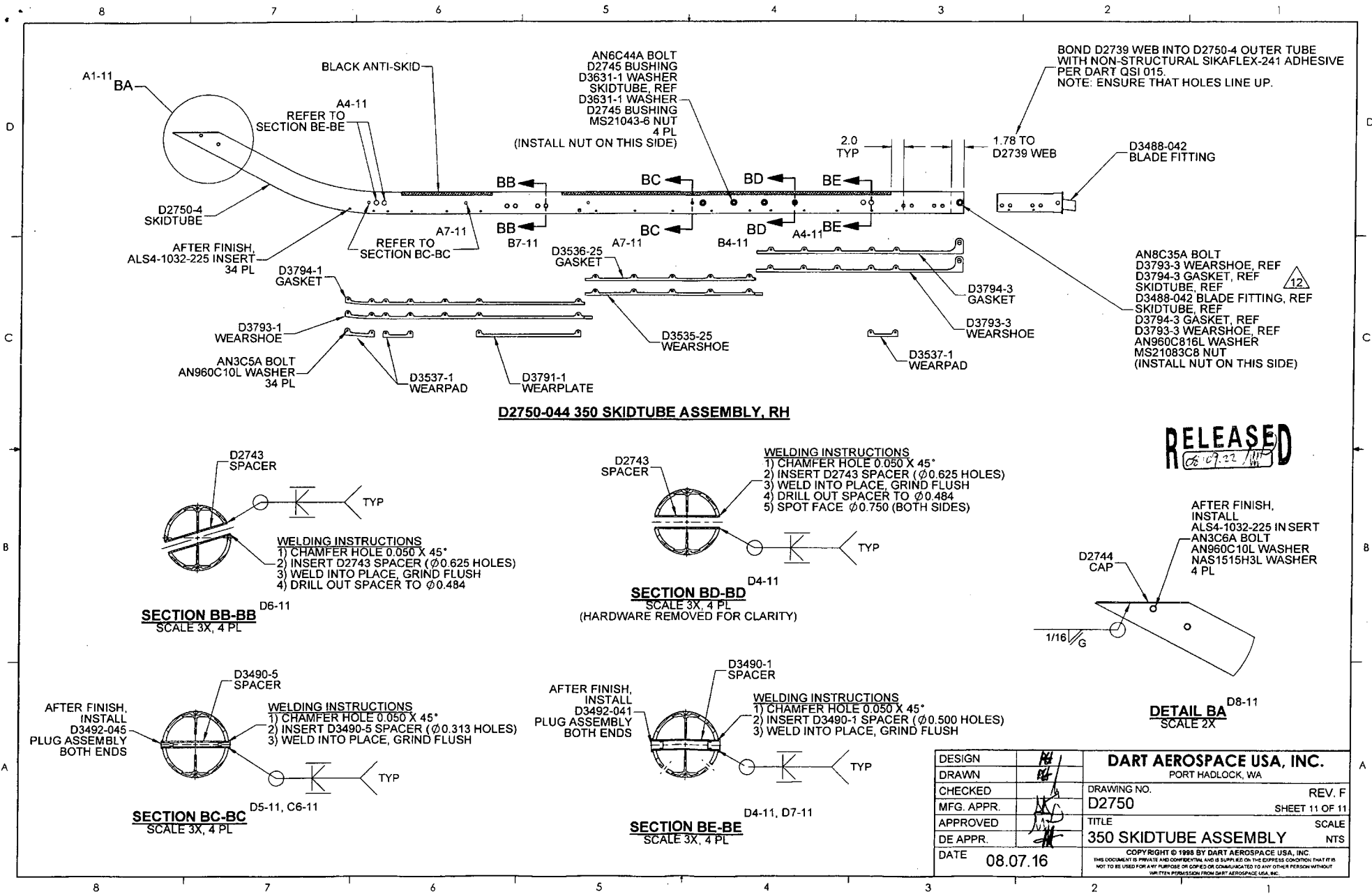
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

76057



DESIGN	REV. F	DART AEROSPACE USA, INC.	
DRAWN	REV. F	PORT HADLOCK, WA	
CHECKED	REV. F	DRAWING NO.	REV. F
MFG. APPR.	REV. F	D2750	SHEET 11 OF 11
APPROVED	REV. F	TITLE	SCALE
DE APPR.	REV. F	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC.	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

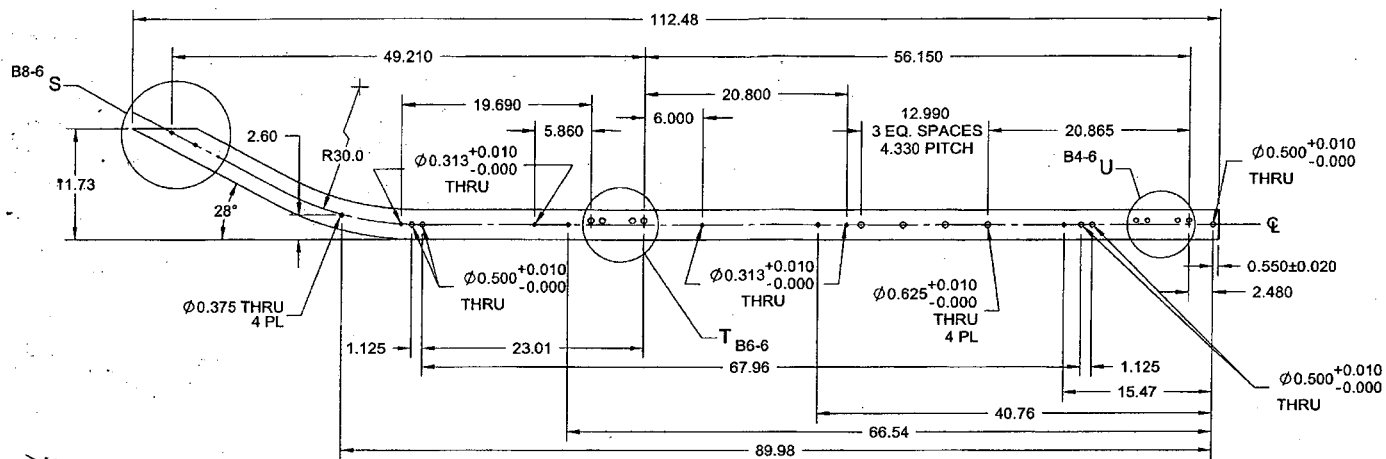
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

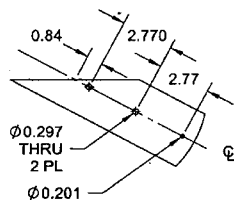
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

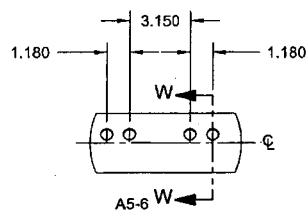
8 7 6 5 4 3 2 1



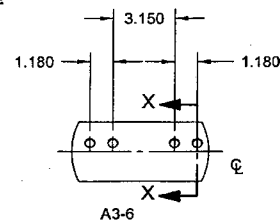
**D4168-3 LH SKIDTUBE**



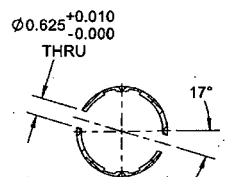
**DETAIL S**  
SCALE 2X



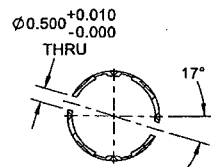
**DETAIL T**  
SCALE 2X



**DETAIL U**  
SCALE 2X



**SECTION W-W**  
SCALE 3X, 4 PL



**SECTION X-X**  
SCALE 3X, 4 PL

**RELEASED**  
2010-09-15  
MM

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4168	SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	10.08.09	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

## 6.0 PARTS LIST

(D350-636-011/-012/-013/-014 SKIDTUBES AT CHANGE 004 OR LATER)

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -045	Part Number	Description
	X					D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		X				D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
			X			D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRAISER/ APICAL TRI-BAG FLOAT COMPATIBLE
				X		D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRAISER/ APICAL TRI-BAG FLOAT COMPATIBLE
					X	D350-636-045	WEARSHOE KIT
1	1					D2750-041	SKIDTUBE ASSEMBLY, LH
1		1				D2750-042	SKIDTUBE ASSEMBLY, RH
1			1			D2750-043	SKIDTUBE ASSEMBLY, LH
1				1		D2750-044	SKIDTUBE ASSEMBLY, RH
*1	1					D2750-1	SKIDTUBE WELDMENT, LH
*1		1				D2750-2	SKIDTUBE WELDMENT, RH
*1			1			D2750-3	SKIDTUBE WELDMENT, LH
*1				1		D2750-4	SKIDTUBE WELDMENT, RH
**2	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8		22541N120	NUT
*5	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1		AN960C816L	WASHER
*7	1	1	1	1		MS21083C8	NUT
*8	1		1			D3488-041	BLADE FITTING, LH
*8		1		1		D3488-042	BLADE FITTING, RH
9	1	1	1	1		D2741	BLADE I
10	2	2	2	2		AN8C21A	BOLT
11	2	2	2	2		AN960JD816	WASHER (OR NAS1149DO863J) I
12	2	2	2	2		MS21083C8	NUT I
*14	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8		D2745	BUSHING
*16	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4		AN960C10L	WASHER
*20B	4	4	4	4		NAS1515H3L	WASHER

(CONTINUED ON NEXT PAGE)

(CONTINUED FROM PREVIOUS PAGE)

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -045	Part Number	Description
*22	3	3	3	3	3	D3537-1	WEARPAD
*22A	1	1	1	1	1	D3791-1	WEARPLATE (REPLACES D3537-1)
*23A	1	1	1	1	1	D3793-1	WEARSHOE (REPLACES D3535-13)
*23B	1	1	1	1	1	D3794-1	GASKET (REPLACES D3536-13)
*24A	1	1	1	1	1	D3535-25	WEARSHOE
*24B	1	1	1	1	1	D3536-25	GASKET
*25A	1	1	1	1	1	D3793-3	WEARSHOE (REPLACES D3535-35)
*25B	1	1	1	1	1	D3794-3	GASKET (REPLACES D3536-35)
*26A	34	34	34	34	34	AN3C5A	BOLT
*27	34	34	34	34	34	AN960C10L	WASHER
*28	34	34	34	34		ALS4-1032-225	INSERT
*30	8	8	8	8		D3492-041	PLUG ASSEMBLY
*31	8	8				D3492-043	PLUG ASSEMBLY
*32			8	8		D3492-045	PLUG ASSEMBLY
***43	2	2	2	2		D3493-1	WASHER I
50	2	2	1			D3532-1	SPACER I

\* PART OF D2750-041/-042 OR D2750-043/-044 ASSEMBLY

\*\* TO BE SUPPLIED BY CUSTOMER

\*\*\* ONLY INSTALLED IF INSTALLING AN APICAL FLOAT SYSTEM

NO. 276

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliot  
Job number: 75349  
Part number: 350-636-012  
Description: Skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Alum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier David Auld Date of Test Coupon 11.11.22  
Welder Barclay Elliot Date of Test Coupon 11.11.22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld